

Work Order ID 118446

118446

Page 1

Thursday, April 02, 2015 10:20:30 AM

Item ID: D212-664-101 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Crosstube - High
 Start Date: 9/2/2014 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/3/2014 Req'd Qty: 1.00 *1* Customer: CEAGL01
 Reference: RMA RA111820

Approvals: Process Plan: UMF Date: 15-4-2 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-141	E								

100

0.00

100

QC

Quality Control

Memo

INSPECT RA 111820 D212-664-101 X 1 3101950

CROSSTUBE IS VERY CORRODED

MEASURE ALL SPANS , ANGLES AND CRUSHING FOR REFERENCE TO
THE AMOUNT OF HOURS TUBE HAS BEEN USED

ENSURE ORIGINAL REMOVAL TAG IS ATTACHED TO THE RA WORK
ORDER

SEE ATTACHED FOR MORE DETAILS

GIVE TO ENG

SCRIBE "SCRAP " IN CENTER SECTION OF CROSSTUBE AND RA111820

SCRAP

① 150608 ①

P.T.O.

DQA:

Date: 15/06/16



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/06/12

Work Order update only

Work Order: 118446		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. D212-664-101		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒		
NCR No. 15-5094		Scrap ☒		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
Suspected Unapproved ☐				Large Fab ☐	Composite ☐	Supplier ☐			
Date: 15-06-08		Step #: 100		QTY Effective: ①			MRB (Q51042) Approval		
Description Work Order Deviation				Disposition				DAS Completed By	
no good use for engineering.				Scrap + destroy				49 9-89 15/06/09	
								Lead hand / Supervisor Approval Verification	
								15-06-09 DAS 9	
								QC / QA Coordinator Approval	
								15-06-09 DAS 9 9-89	
Root Cause		FAULT CATEGORY							
Environment ☒	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☒				
Equip/Tooling ☒	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☒	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER: C							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

QC21- Final Inspection - Work Order Release

0.00

110

QC

Memo

0.00

Quality Control

MUS 

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Thursday, April 02, 2015 10:20:30 AM

Page 1

Work Order ID: 118446

118446

Parent Item: D212-664-101

D212-664-101

Parent Item Name: Fwd Crosstube - High

Start Date: 9/2/2014

Required Date: 9/3/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E04.02.16ReformatKJ/DS
 IPP Rev:F 06-03-29 Remove Coments on Pick List JLM
 IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H
 11.04.26 inspection strip ecn 11-549 EC verf by:DD IPP REV:I 14.05.27
 AS PER ECN 14-570 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-664-101		Manufactured	No				Each	9.0000		1			

D212-664-101

Fwd Crosstube - High

1X 101950

Location	Loc Qty	Loc Code
FG	4	
119982	1	
120017	1	
122322	1	
123286	1	
FG098	3	
128704	1	
128706	1	
128707	1	
FG103	2	
123284	1	
123285	1	

mf

15-3-2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation		Disposition		Completed By																	
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Root Cause		FAULT CATEGORY																			
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OTHER :																					

RA 111820 D212-664-101

B101950

Received @ Dart July 31st, 2014
Inspected@ Dart August 22nd, 2014

CUSTOMER: HELISERVICIO CAMPECHE
CUSTOMER CONTACT: ROSARIO MENESES
SHIPPED FROM: MEXICO

Instructions for RA 111802 D212-664-101 B101950

11/8/16

- Cross tube is very corroded
- All corrosion appears to be in locations where the top coat (paint/primer) has been damaged
- Corrosion due to alodine process not being completely controlled (NCR 12-1657)
- Measure all spans, angles and crushing for reference to the amount of hours that tube has been used (fill out x-tube FAI)
- Ensure original removal tag is attached to the RA work order
- Create work order to scrap cross tube.
 - Scribe scrap in center section of tube and RA111820
 - Give tube to engineering
- Open par to recommend necessary changes to the alodine process

Time Estimate = 3 HOURS

Departments Required: Quality Control

Pictures Attached = Yes

QTY INSPECTED = x1 D212-664-101 B101950

**THIS INSTRUCTION SHEET MUST
BE ATTACHED TO THE
RESTOCKING WORK ORDER AT
ALL TIMES!!!!**

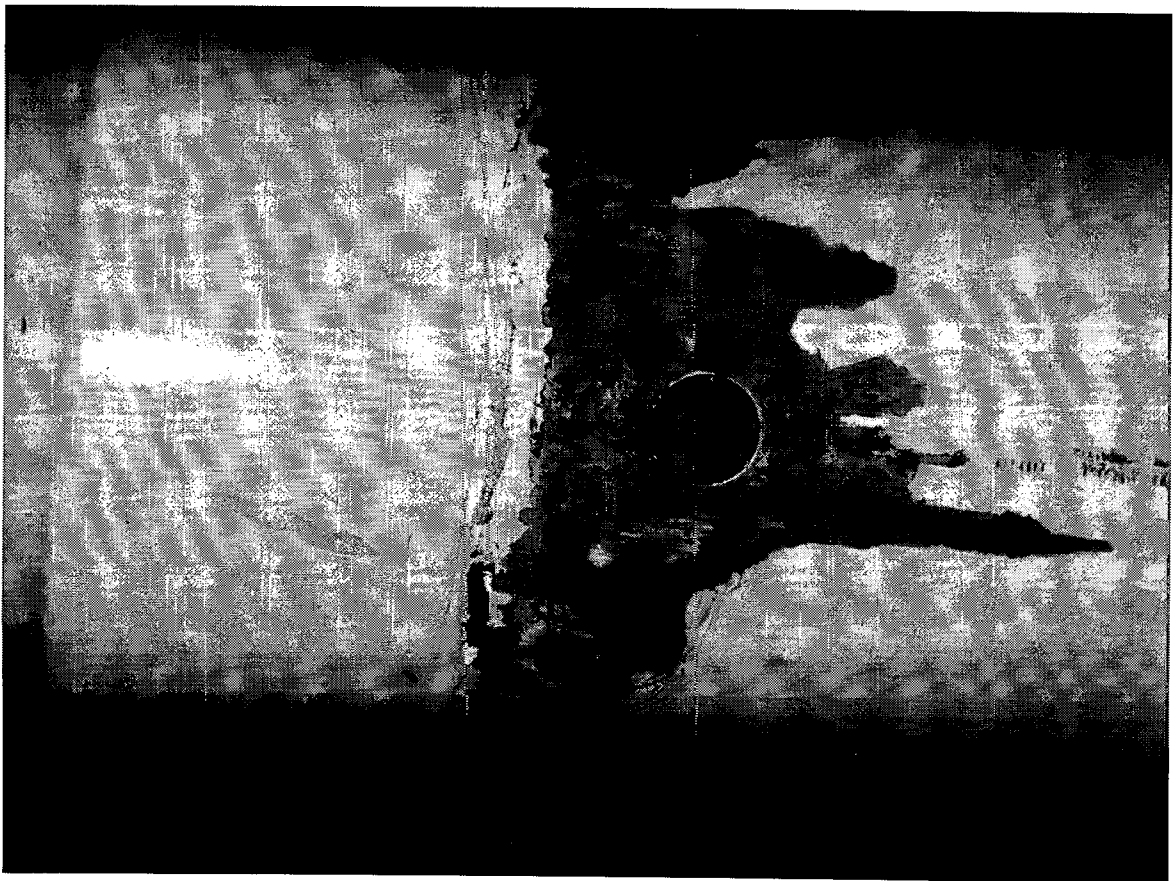
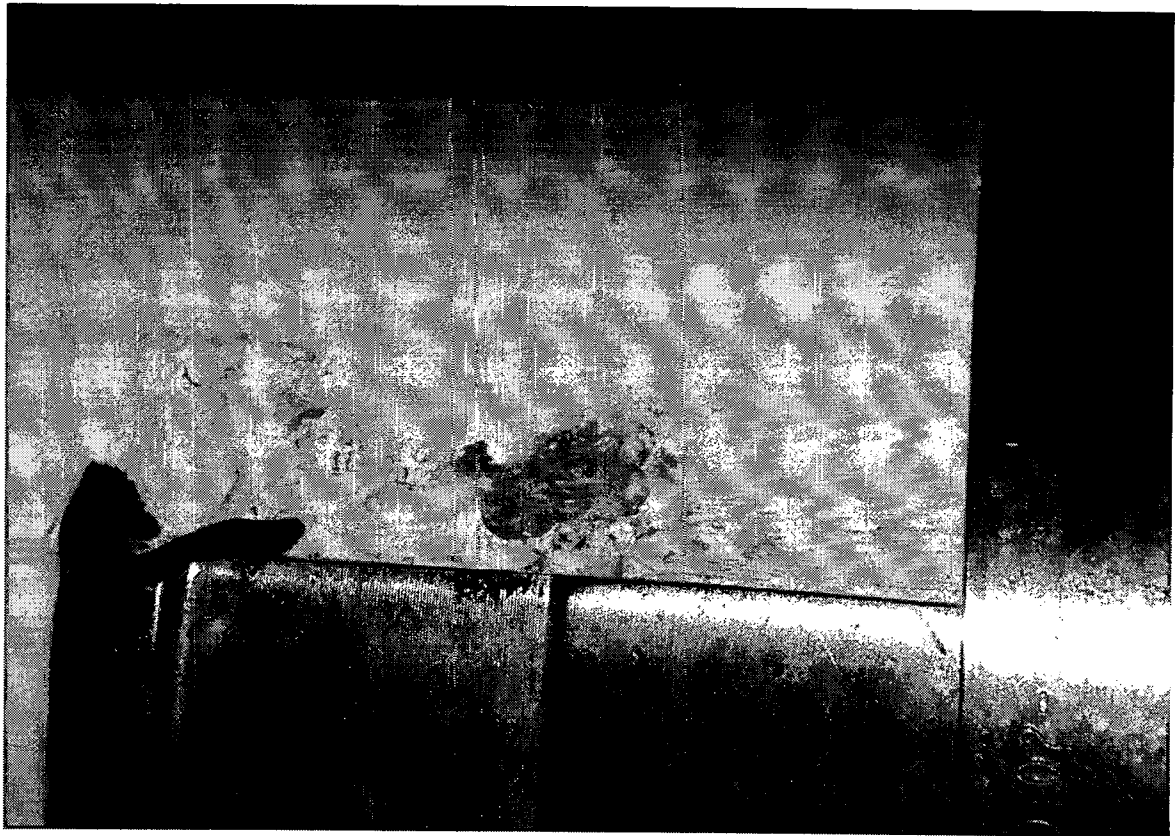
WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due		FAULT CATEGORY Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
		OTHER :							



DQA: _____ Date: _____

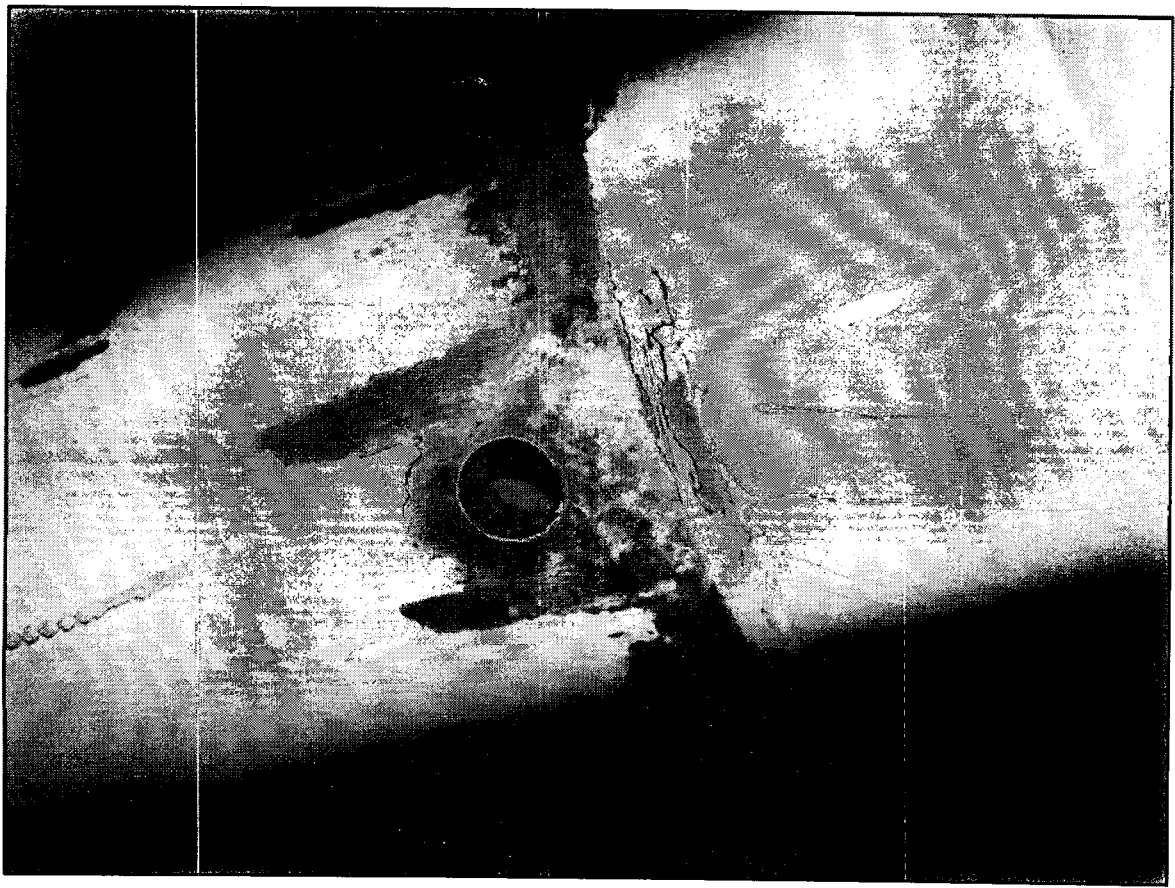


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Heliservicio

TALLER AUTORIZADO DGAC No.81
ANTIGUA TERMINAL AEROPUERTO
CD DEL CARMEN, CAMP. 24170

DESCRIPCION: Crosstube Fair High

NUMERO DE PARTE: D212-664-101

NUMERO DE SERIE: B101950

T.T. 26 T.S.O. 26 T.S.I. 26

RAZON DE REMOCION: Por presentacion

Removido de la Aeronave: XA-1150 Fecha:

Tiempo total de la aeronave: 7952.20

Técnico: Tomas Rodriguez Firma: [Signature]

Inspector: Guillermo Lalo Perez Sello: [Stamp]

HC-FO-42 (1)